

Date: Thursday, 2/14/2008 2:21:58 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	ACCESS PANEL
Job Number	37464		
Estimate Number	12500		
P.O. Number	:	Part Number	D32551
This Issue	2/14/2008	Drawing Number	D3255 REV B
Prsht Rev.	NC	Project Number	N/A
First Issue	/ /	Drawing Revision	B
Previous Run	33605	Material	:
Written By	<u>JL</u> 08 02 14	Due Date	2/25/2008
Checked & Approved By		Qty:	6
Comment	Est Rev:A New Issue 06-08-01 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S22GA	304/316 .032 Sheet
		13
	Comment: Qty.: 1.5582 sf(s)/Unit Total : 9.3492 sf(s) 304/316 .032 Sheet (M304S032) Batch: <u>106419</u> <u>B</u> 8-2-20	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3255 Dwg Rev: <u>B</u> <u>B</u> 8-2-20 Prog Rev: <u>B</u>	8
	2-Deburr if necessary	<u>HB</u> 8-2-20
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<u>HB</u> 8-2-20
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	8
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	<u>106419-20</u> 8 counted
5.0	BRAKE NC	NC BRAKE
	Comment: NC BRAKE Form as per Dwg D3255	<u>FF</u> 08-05-02
		8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL

Job Number: 37464

Part Number: D32551

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/07 (8)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CSSL

L 08/05/07 (8)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/07 (8)

Job Completion



MF 08-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37464
Description: Access Panel Assembly	Part Number:	D3255-1
Inspection Dwg: D3255 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

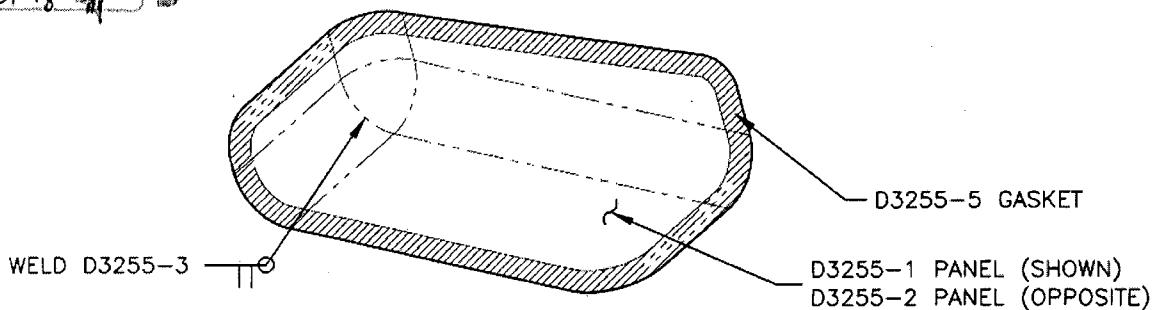
X First Article Prototype

Measured by:	<u>B</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8-2-20	Date:	08-02-20	Date:	N/A

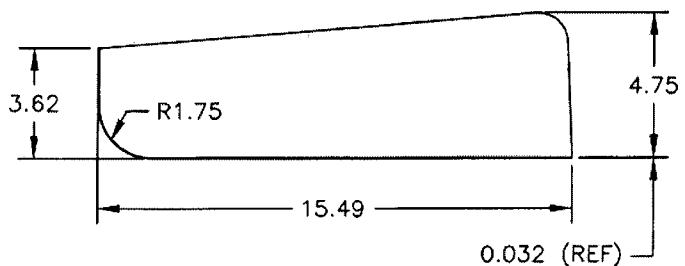
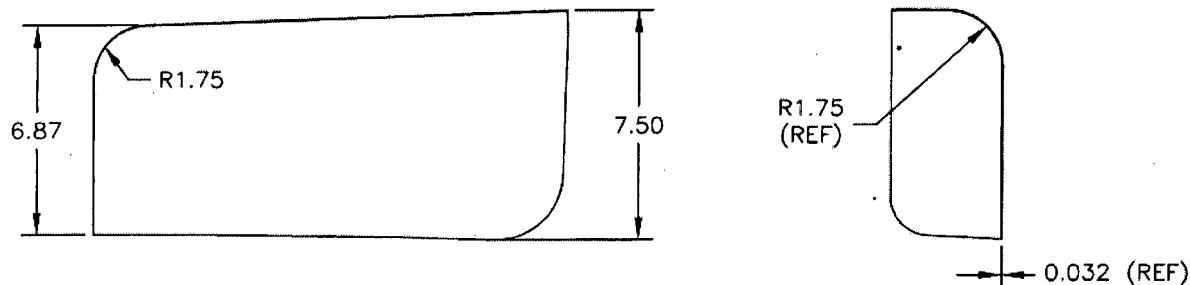
Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	

DART

DESIGN <i>P</i>	DRAWN BY <i>T</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37464*

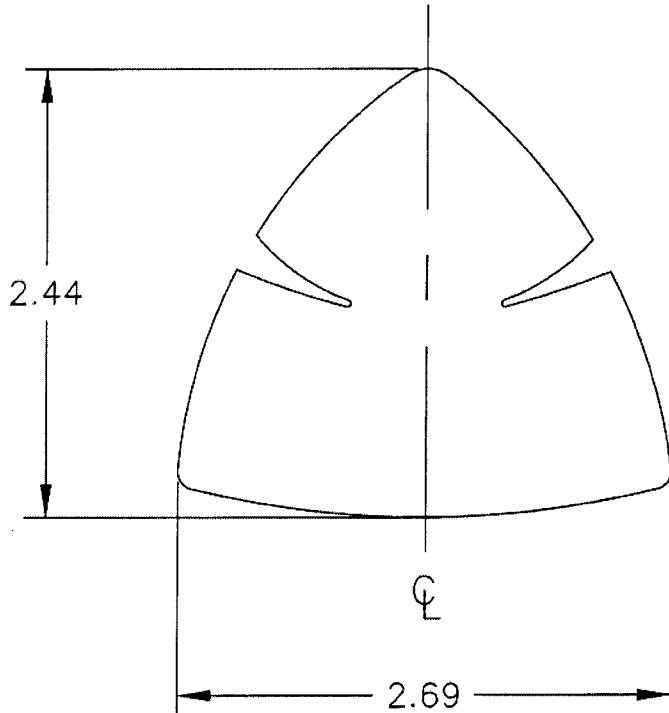
D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P	APPROVED H	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-18 H



D3255-3 CAP
FORM TO FIT D3155-1/-2

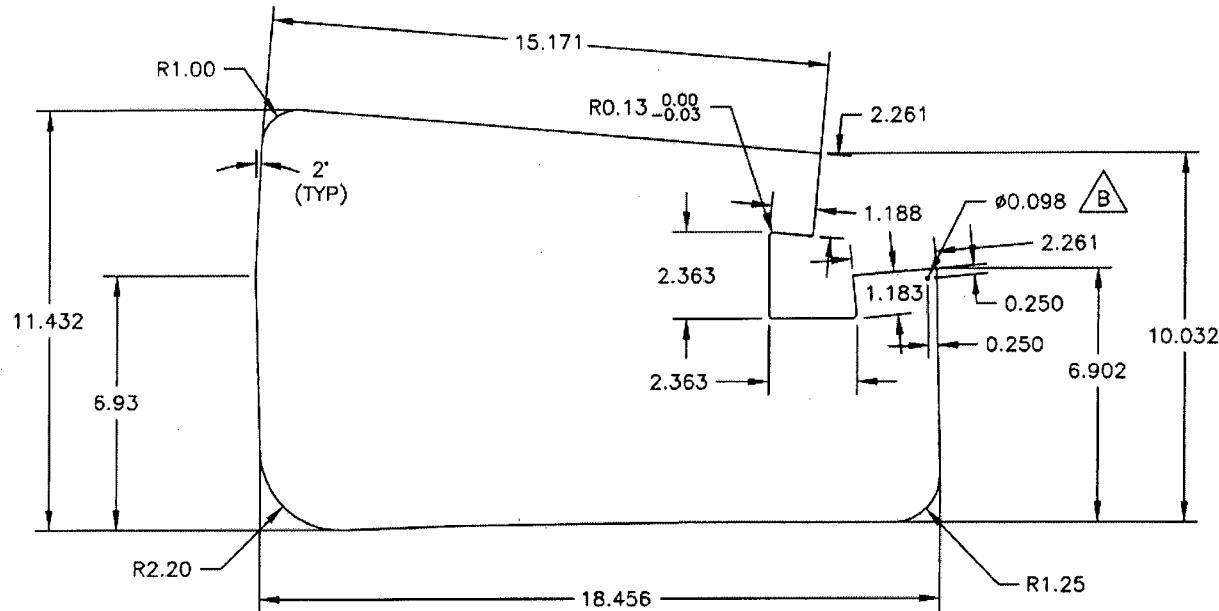
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37464

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED GP	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18**D3255-1/-2 FLAT PATTERN**

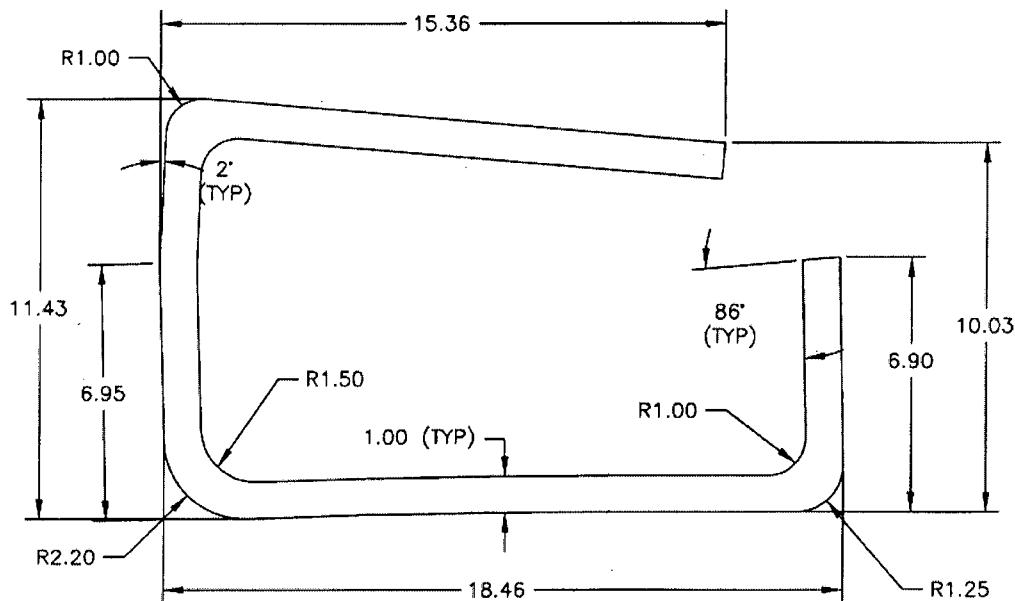
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37464

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

DART

DESIGN <i>TT</i>	DRAWN BY <i>TT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>TT</i>	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:5

RELEASED
05.01.18 *TT***D3255-5 GASKET**

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *37464*

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES